

Work Order ID 61891-2

SPUT

September 9, 2010 10:11:50 AM



Page 1

Item ID: D2807-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door prop

Start Date: 9/09/10

Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/10

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 10/9/9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2807

Rev E

100



Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: 12540 ☐ Order as per Dwg D2807 ☐ Possible  
supplier: Lift Support Technologies, Saskatoon, Canada ☐ P/N 6/15-164/50-115N  
☐

Material release note is required

CL 10/9/9 (20)

110



Packaging

Packaging

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

Memo

0.00

Ensure Material Release Note is attached

Cool/1/27 (11)

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

S 10/02/27

(11)

LS Technologies Canada Inc.

PH: (306) 683-5000 www.lstechnologies.ca

D2807

09/23/2010

Warranty void if label removed  
HIGH PRESSURE! DO NOT HEAT, PUNCTURE / DO NOT APPLY SIDE FORCE

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09/23/2010

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September 9, 2010 10:11:50 AM



Page 2

Item ID: D2807-041

Accept



Setup Start



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Item Name: Door prop

Start Date: 9/09/10

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Cust Item ID:

Required Date: 9/15/10

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

I-install D3671-1 as per dwg D2807

SP 09/09/30 (11)

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

SP 10/09/30

(11)

150



Packaging

Identify as per dwg & Stock Location: 023

0.00

Memo

0.00

Packaging

R 11/5/30 (11)

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D2807

09/23/2010

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# Work Order ID 61891

September 9, 2010 10:11:50 AM



Page 3

Item ID: D2807-041

Accept



Setup Start



Revision ID:

Item Name: Door prop

Stop



Start Date: 9/09/10

Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/10

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

-10/10/01 *[Signature]*

*mf*  
10-9-30

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D2807

09/23/2010

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D2807

09/23/2010

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HIGH PRESSURE! DO NOT HEAT, PUNCTURE / DO NOT APPLY SIDE FORCE

# Picklist Print

September 9, 2010 10:11:49 AM

Page 1

Work Order ID: 61891

Parent Item: D2807-041

Parent Item Name: Door prop



Start Date: 9/09/10

Required Date: 9/15/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD  
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6/15-164/50-115N 		Purchased		No		130	Each	0.0000	1	20			
Gas Spring D3671-1 		Manufactured		No		110	Each	19.0000	1	20			
Placard													

Location

ST074

61643

B61892

Loc Qty

19

19

Loc Code

(1x)

10 10 10

CL 10/09/27 (11)

SP 10/09/30

# SPECIFICATION CONTROL DRAWING

C/L 10/9/19  
W10:61891

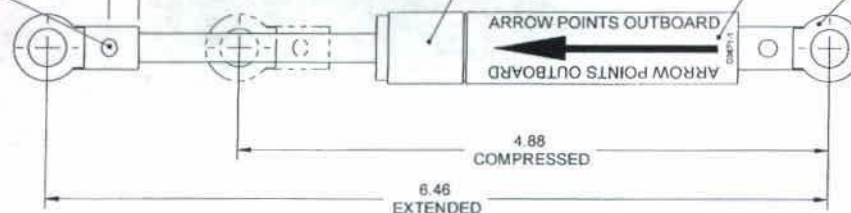
(ALTERNATE ONLY)  
CRIMP 0.015-0.025 DEEP  
WITH Ø0.375 TOOL AT  
2000psi (REF), TYP TWO  
SIDES PER LUG

0.24 TO CRIMP  
(TYP)

D2807-5  
OR  
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD  
ENSURE PLACARD DOES NOT  
CONCEAL ANY TEXT OR MARKINGS  
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3  
BOTH ENDS



D2807-041 GAS SPRING

## D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

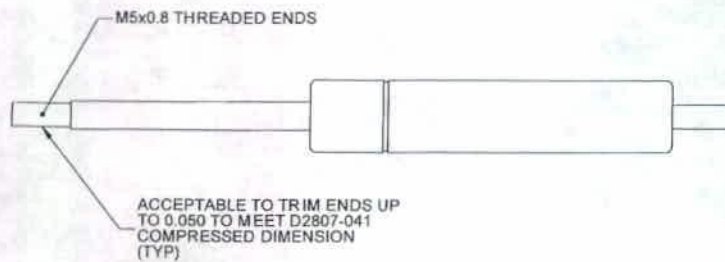
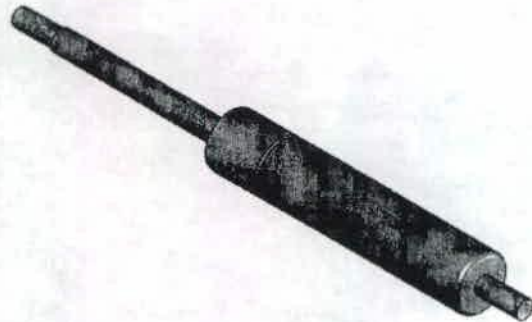
### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)  
(WEIGHT: 0.176 LBS)

E	ADD D2807-5 GAS SPRING; D2807-11-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE

DESIGN	JE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JE		
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.	JE	D2807	SHEET 1 OF 3
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	GAS SPRING	NTS
DATE	07.12.28	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR LOANED OR REPRODUCED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

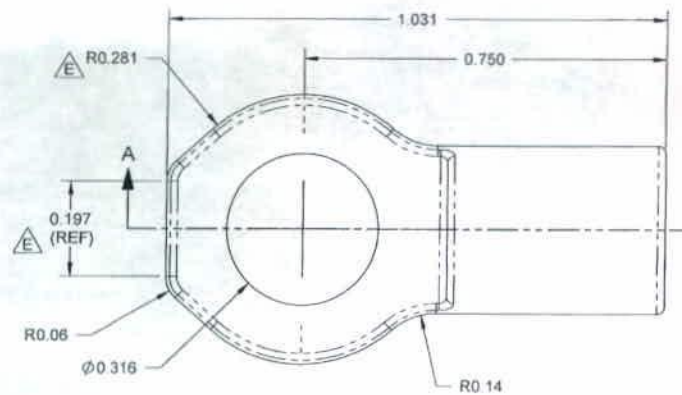
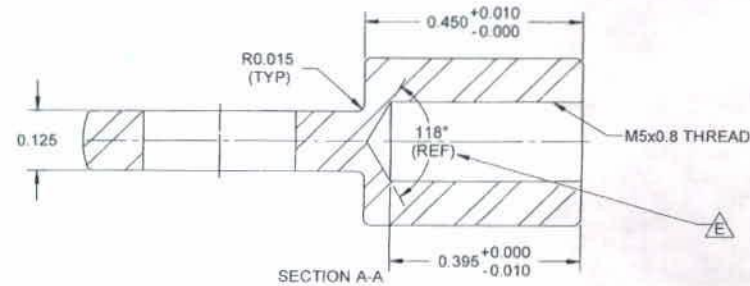




**D2807-1 GAS SPRING**  
SCALE 1:1

**D2807-1 GAS SPRING NOTES:**

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK  
(P/N SXF6S6050080S6L-115N)  
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX  
M5x0.8 THREADS

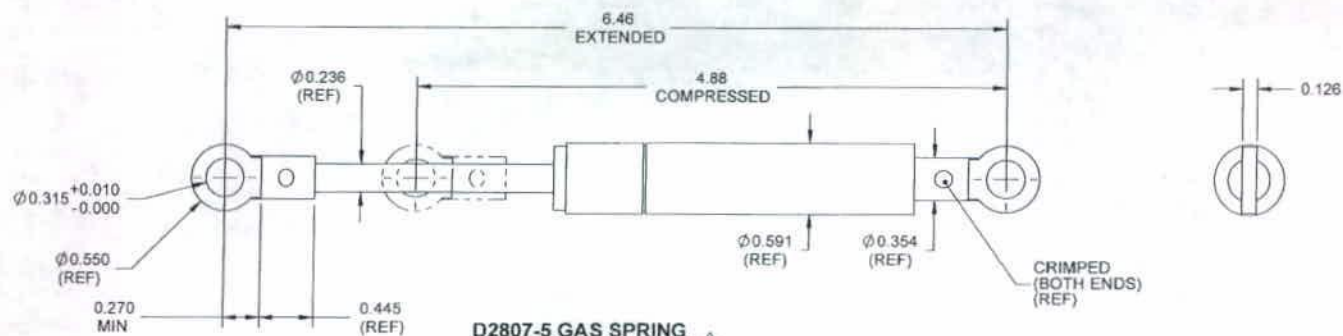
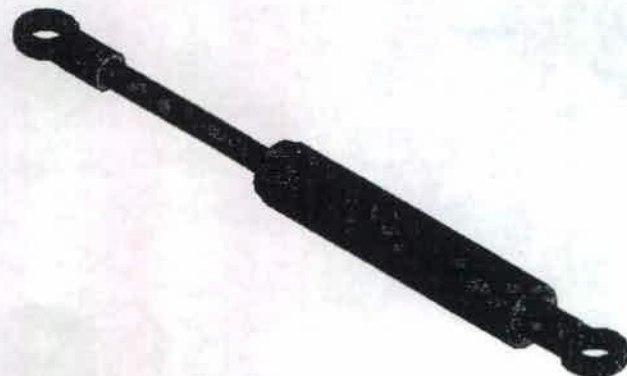


**D2807-3 LUG**

**D2807-3 LUG NOTES:**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	HA	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HA		
CHECKED	JE	DRAWING NO. <b>D2807</b>	REV. E
MFG. APPR.		TITLE <b>GAS SPRING</b>	SHEET 2 OF 3
APPROVED		SCALE 4:1	
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**D2807-5 GAS SPRING**



**D2807-5 GAS SPRING NOTES:**

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS, ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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DE APPR.	LE		
DATE	07.12.28		



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO12540

Purchase Order Date 9/09/10

PO Print Date 9/09/10

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.  
303-103 STREET  
SASKATOON, SK S7N 1Y9  
CA

Contact Name  
Vendor Phone 306 683 5000  
Vendor Fax 306 683 6403  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency CAD  
FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FIXED  
FC 9/9/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	6/15-164/50-115N	Gas Spring	9/15/10 Yes	20.00 Each	FedEx Pl ppd	\$63.9000	\$1,278.00
Special Inst: AS PER DWG D2807 REV. E B61891 LS TECHNOLOGIES P/N: 6/15-164/50- 115N							
PO Total:							\$1,278.00

CERTIFICATE OF CONFORMITY  
REQD UPON DELIVERY

Change Nbr: 1

Change Date: 9/09/10

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



LS Technologies Canada Inc.

303 - 103 Street  
Saskatoon, SK Canada  
S7N 1Y9

## Packing Slip

Date	Invoice #
9/23/2010	6529

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
12540	9/23/2010			

Qty	Description
11	<u>D2807 Stainless Gas Spring (6/15-164/50-115N)</u> Shipping and Handling UPS - Tracking # 1ZV659Y21445421135

*S. 10/07/10*



303 – 103<sup>rd</sup> Street, Saskatoon, Saskatchewan, Canada S7N 1Y9  
Ph: (306) 683-5000 Fax: (306) 683-6403  
E-mail: [lstech@lstechnologies.ca](mailto:lstech@lstechnologies.ca) [www.liftsupporttechnologies.com](http://www.liftsupporttechnologies.com)

### Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

11 Units: D2807 Stainless Gas Spring (6/15-164/50-115N)

Country of Manufacture : Canada

Date of Manufacture : Sept 2010

This product is ROHS compliant.

Purchase Order # 12540

*Solomon*

L S Technologies Inc Canada

  
Nolan Fehr  
President